Tem ID: D3161-9	Page 1
Start Date: 10/07/13 Start Qty: 6.00	*)*
Approvals: Process Plan:	
Work Center ID Description Run Hours Code Qty Qty Number Stand Revision Nbr D3161 Rev A2 100 Small Fab Memo (1) 72" Hinge makes (4) D3161-9 parts at 17" longCut to length as per Dwg D3161	*)*
D3161 Rev A2	
100 0.00	
100 Small Fab Memo 0.00 Small Fab (1) 72" Hinge makes (4) D3161-9 parts at 17" longCut to length as per Dwg D3161	
2.4	30
DAS 27 9-89	
120 Identify as per dwg & Stock Location: \$\frac{5703}{0.00}\$ *120 \[\begin{array}{cccccccccccccccccccccccccccccccccccc)

Memo

120 Packaging

Packaging

						•				DQA:	Date	•
NCR: Y	es / N	0			WORK ORDER NON-O	COI	NFORM	√ANCE / UP	DATE	QA Closed:	Date	•
					DISPOSITION				AGAINST DE			
Work Orde	er:				_	_				, 1		.
Part No.			Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other		
NCR No.				Work Order Update]		Large Fab	Composite		Supplier		
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material		:										
Setup												
Other			1			l						
Process		1				İ						
Supplier												
Training												
Unapproved						<u> </u>						
						AUL	LT CATE	GORY				
Landi	ng Gear			_	General	_	7		_	٦	<u></u>	¬
	_	Bending		Bend	_	Grain		<u></u>	Ovalized	<u> </u>	Pressure/Forced	
	Centre Not Concentric to O/S		BOM/Route	\vdash	Hardwa			Over/Under	<u> </u>	Temperature/Cure		
	Cracks		Broken/Damaged	\vdash	4	ion Incomplete		Part Incorred	<u> </u>	Weld		
	Crushed/Crimped		Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs		Contamination	\perp	Mainte		<u> </u>	Part Moved				
	Heat ⁻				Countersink	<u></u>	Mislabe		<u> </u>	Positioned V	_	7
		tion Strip in			Cut Too Short		Misread	i		Power Loss/	Surge	Other
	⊢	s in Bend			Drill Holes		Offset					<u></u>
	Torque Waves in Extrusion			Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Ordo		8134	in the state of the in-	*108	3134*			res e 2 2	Page 2
Item ID: Revision ID: Item Name:	D3161-9 Hinge 17.0"			Accept	*N900	040100)* Setu _l	p Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	10/07/13 10/07/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept R Qty / Q	ty [Reject Insp. Number Stamp

0.00

Memo

130

Quality Control

Af /2m 13/10/10 MK 13/10-10

NCR: Y	es / No				WORK ORDER NON-C	CON	IFORN	ANCE / UP	DATE	•		
										QA Closed:	Date	;
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No			Scrap Machining Small Fab Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other					
Root		I		Doscri	ption of work order update	1	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
Landin	g Gear				General	AUL	T CATE	JURY				
Candil	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instructi Mainte Mislabe Misread Offset	on Incomplete ions incomplete/U nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Picklist Print

October-07-13 9:12:15 AM

Work Order ID:

108134

Parent Item:

D3161-9

Parent Item Name:

Hinge 17.0"

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route · Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	47.3816	1.65	9.9	5/3	10/	0
Tallo Hinge				Location		Loc Oty	<u>Lo</u>	c Code				7-1	
				ST209a		47.3815788							
				1239	960	2.2447368			-				
				ml2	6275	45.136842			_7.	7'			

Page 1

										DQA:	Date	:	
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	AANCE / UP	DATE	0.4.611			
	_									QA Closed	Date		
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No.					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing			4	Water Jet od. Eng. Coor.	Engineering Quality Other			
NCR N	lo				Work Order Update Large Fab Composite				Composite	Supplier			
Root		1		Descri	ption of work order update		nitial	Act	tion	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator									•				
Material													
Setup													
Other							•						
Process													
Supplier													
Training													
Unapproved						<u>l</u> .							
					F	AUL	T CATE	GORY					
Landi	ng Gear				General					_		_	
	Bending			Bend		Grain			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S			BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	Cracks			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld		
	Crushed	/Crimped			Burrs		Instruct	ions incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Tre	at			Countersink		Mislabe	led		Positioned '	Wrong	_	
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	/Surge	Other	
	Ripples in Bend			Drill Holes		Offset			_				

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

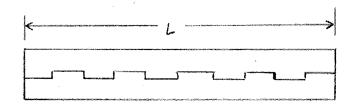




Di	ESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	
C	HECKED RF	APPROVED	DRAWING NO.	REV. A
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DATE	02.04.24	TITLE HINGE	SCALE NTS
Α	02.04.24	NEW ISUE	
AI	H \$ 04.02.27	ADDED 03161-5	
<u>A Z</u>	DA 04.06.30	ADD 03161-7 & 03161-9	

P/N	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON D2183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
D3161-5	9.9"	HINGE
03161-7	14,0"	HINGE
03161-9	17.0"	HINGE.



NOTES:

1) MAKE FROM MS20257-3-7200 HINGE

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